

order 4087

24 DEC



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2806-1

Job Sheet 187725

PO# 42294



Part No: D2806-1

Job Qty: 20 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/18

Job Tracking No:

Due Date: 12/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP: B 05.03.11 Part now turned KJ/JLM IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs		12/24/18	0.00	2.09	Doosan - 1		 12/19/01/21
120	QC 8	20 pcs		12/24/18	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 16		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
130	Handfinish - 1-1 Chemical-B4B	20 pcs		12/24/18	0.00	0.27	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
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www.dartaerospace.com

Container No: S146106



Part: D2806-1

Job No: 187725

Serial No/Batch: S146106

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/21/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							

					Handfinish - 1 - 10 - B4B	D.R 19/01/22
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
140 QC 7	20 pcs	12/24/18	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 16	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	UAS
					QC 7 - 38	38
					QC 7 - 41	9-88
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
150 Packaging 3-1 - Stock - B4B	20 pcs	12/24/18	0.00 0.00		Packaging 3 - 1 - B4B	Stoll JAN 23 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	

Entered: _____ Date: _____



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Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details:			

			Packaging 3 - 9 - B4B
			Packaging 3 - 10 - B4B
			Packaging 3 - 11 - B4B
			Packaging 3 - 12 - B4B
			Packaging 3 - 13 - B4B
			Packaging 3 - 14 - B4B
			Packaging 3 - 15 - B4B
			Packaging 3 - 16 - B4B
			Packaging 3 - 17 - B4B
			Packaging 3 - 18 - B4B
			Packaging 3 - 19 - B4B
			Packaging 3 - 20 - B4B
			Packaging 3 - 21 - B4B
			Packaging 3 - 22 - B4B
			Packaging 3 - 23 - B4B
			Packaging 3 - 24 - B4B
			Packaging 3 - 25 - B4B
			Packaging 3 - 26 - B4B
			Packaging 3 - 27 - B4B
			Packaging 3 - 28 - B4B
			Packaging 3 - 29 - B4B
			Packaging 3 - 30 - B4B
			Packaging 3 - 31 - B4B
			Packaging 3 - 32 - B4B
			Packaging 3 - 33 - B4B
			Packaging 3 - 34 - B4B
			Packaging 3 - 35 - B4B

160 QC 21 - SA 20 12/24/18 0.00 0.00
 pcs

QC 21 - SA - 16

DAG 21 JAN 24 2019

Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FA105 Rev: _____ & Dwg D2806 Rev: _____ 2-Debur per dwg D2806
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Identify as per dwg & Stock Location: _____)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6H1.000	6061-T6 Hexbar 1.00	1.8320 ft (0916 ea)	100-Doosan - 1	5127981

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6H1.000 R1.250	2	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	1.000inches ± 0.010	1.010 0.990		
2	Bushing	1.155inches ± 0.010	1.165 1.145		
3	Bushing	0.250inches ± 0.010	0.260 0.240		
4	Bushing	0.063inches ± 0.010	0.073 0.053		
5	Bushing	45.000Degrees ± 0.000	45.000 45.000		
6	Bushing	0.080inches ± 0.010	0.090 0.070		
7	Bushing	45.000Degrees ± 0.000	45.000 45.000		

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Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
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			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8	Bushing	0.495inches + 0.000 - 0.005	0.495 0.490
9	Bushing	0.750inches + 0.000 - 0.005	0.750 0.745
10	Bushing	0.257inches + 0.005 - 0.000	0.262 0.257
11	Bushing	0.094inches ± 0.010	0.104 0.084

Plex 12/12/18 1:34 PM Dart.lajeunesse.marie

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